

Date: Thursday, 26/10/2006 1:13:46 PM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 29014		
Estimate Number	: 10710		
P.O. Number	: N/A	Part Number	: D32111
This Issue	: 26/10/2006 S.O. No. : N/A	Drawing Number	: D3211 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A1
Previous Run	: 29014	Material	: N/A
Written By	:	Due Date	: 30/10/2006 Qty: 8 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 05-11-17 JLM Est Rev:B Now on Waterjet 06-10-24 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S063	2024-T3 .063 sheet
<p>Comment: Qty.: 1.4753 sf(s)/Unit Total: 11.8020 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063)Identify as D3211-1 Batch: <u>M101022</u> <u>MM 06 11 07</u></p>		
2.0	WATER JET	FLOW WATER JET
<p>Comment: FLOW WATER JET 1-Cut as per Dwg D3211 Dwg Rev: <u>A1</u> Prog Rev: <u>A1</u> <u>MM 06 11 07</u> <u>(8)</u> <u>SAD 06:11:05</u> 2-Deburr if necessary</p>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>MM 06 11 07</u> <u>(8)</u> <u>SAD 06:01:05</u> <u>(A10)</u></p>		
4.0	QC8	SECOND CHECK
<p>Comment: SECOND CHECK <u>MM 06/11/07</u> <u>(8)</u></p>		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
<p>Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr <u>SAD 06:11:12</u> <u>(8)</u></p>		

Date: Thursday, 26/10/2006 1:13:46 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 29014

Part Number: D32111

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend D3211-1 Stack as per Dwg D3211

SB 06/11/16 8

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

MA 06/11/21 (8)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

YLC 06/11/22 X8

9.0

QC3

INSPECT POWDER/COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M.M. 06 11 22 (8)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

FL 06 11 22 (8)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 89

6/14/23 8

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/11/23 (8)

Job Completion



U 06/11/23

Date: Monday, 10/16/2006 2:01:44 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 29014		
Estimate Number	: 10710		
P.O. Number	:	Part Number	: D32111
This Issue	: 10/16/2006	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3211 REV A1
First Issue	: / /	Project Number	: N/A
Previous Run	: 25252	Drawing Revision	: A1
	Type : MACHINED PARTS	Material	:
Written By	: <u> </u>	Due Date	: 10/30/2006
Checked & Approved By	: <u> </u>	Qty:	8
Comment	: Est Rev:A New Issue 05-11-17 JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 1.4753 sf(s)/Unit Total: 11.8020 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.063" thick
 (M2024T3S.063)Identify as D3211-1
 Batch:

2.0	SHEAR	SHEAR
-----	-------	-------



Comment: SHEAR
 Cut blanks: 17.800" x 11.375" (+0.000/-0.010)
 Grain along 11.375"

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3211-1 as per Folio FA348 and Dwg D3211
 Stack of 4

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE



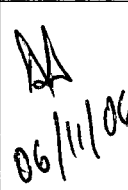

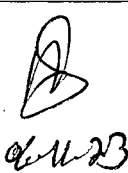
5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/11/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/11/06	3	The programme was not good (Scrap 8)		Destroy and redo	 06/11/06	 06/11/06	 06/11/06	 06/11/06

NOTE: Date & initial all entries

Date: Monday, 10/16/2006 2:01:44 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 29014

Part Number: D32111

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Deburr

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE
Bend D3211-1 Stack as per Dwg D3211

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3211	REV. A SHEET 1 OF 2
DATE 03.09.03		TITLE BRACKET	SCALE 1:3
A	03.09.03	NEW ISSUE	
A1	<i>[Signature]</i> 03.12.05	CHANGE ALL BEND RADIUS TO R0.125	

RELEASED
03.09.15

D3211-1 BRACKET
MACHINE PER DRAWING FILE "D3211-A2.DWG"

CHECK PER TEMPLATE D3211-1T1

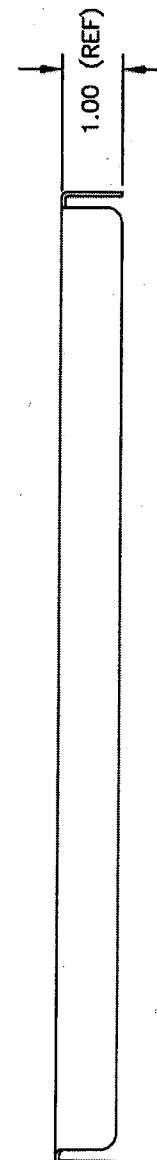
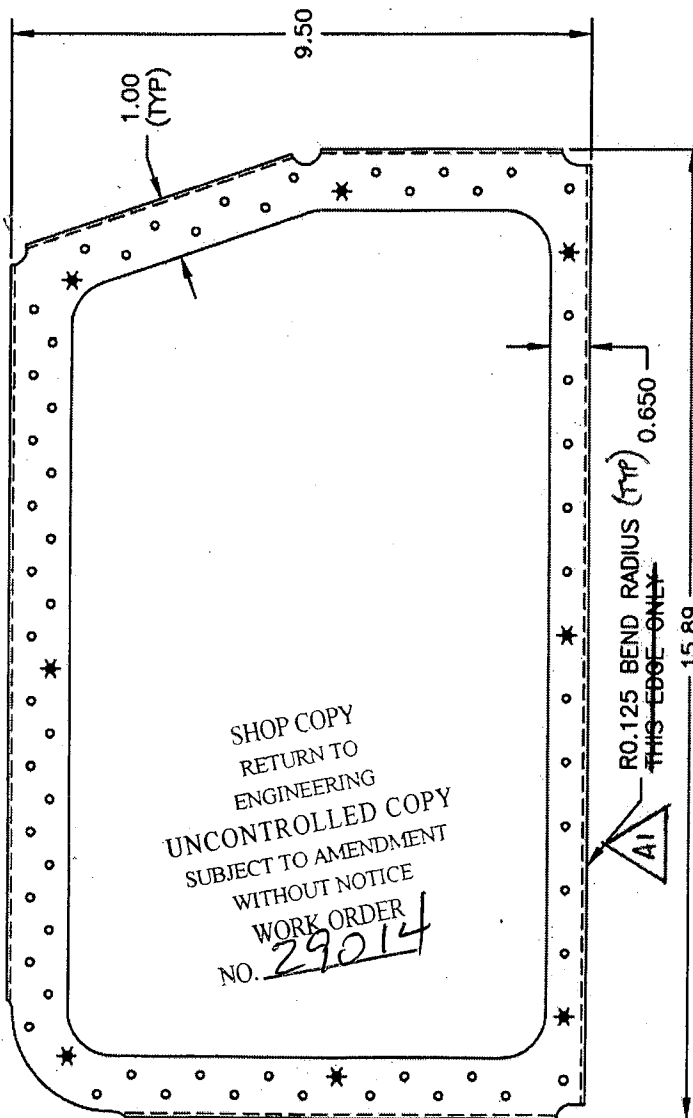
MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3

USE MINIMUM BEND RADIUS OF ~~R0.188~~ ~~EXCEPT WHERE INDICATED~~ ~~R0.125~~

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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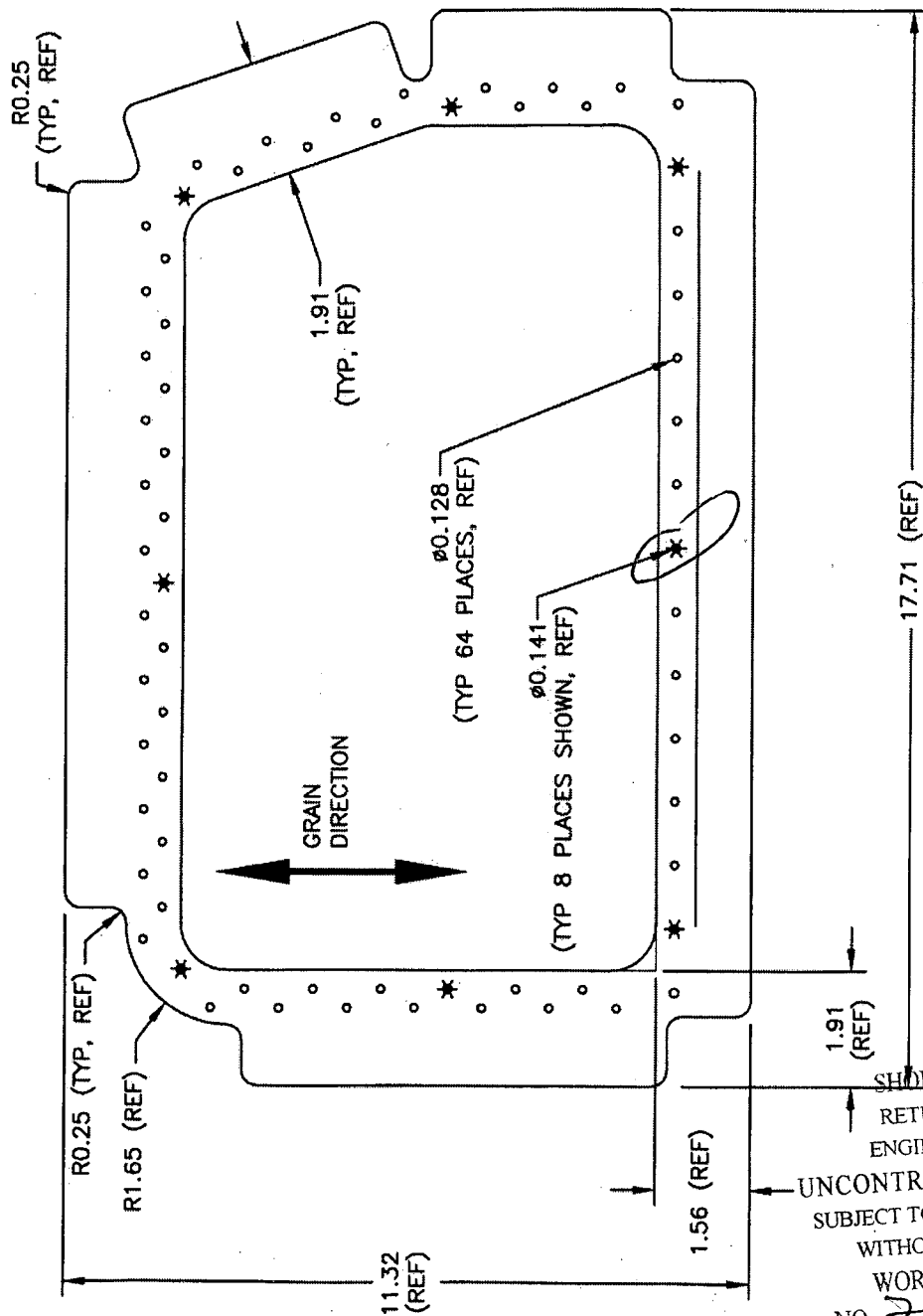
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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3211	REV. A SHEET 2 OF 2
DATE 03.09.03		TITLE BRACKET	SCALE 1:3

RELEASED
03 09 15

D3211-1 FLAT PATTERN



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29014

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DART AEROSPACE LTD	Work Order:	29014
Description: Bracket	Part Number:	D3211-1
Inspection Dwg: D3211-1 Rev: A1		Page 1 of 1